

Work Order ID 94110***94110***

Page 1

November-30-12 9:20:45 AM

Item ID: D412-760-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Cabin Wall and Pylon Protector

Stop

NS2

Start Date: 11/27/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12-12-03 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN D412-760

F

fb

0.00

SmD

100

100

DC

Document Control

Memo

0.00

*12-12-19**12/12/12*

110

110

Packaging

Packaging

Pick Kit

0.00

*sf**12/12/18 fb*

Memo

0.00

120

120

QC

Quality Control

Memo

0.00

SmD

0.00

*12-12-19**j*

NCR: Yes / No

DQA: Date: .

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							
				<input type="checkbox"/> Other							

Work Order ID 94110

94110

Page 2

November-30-12 9:20:45 AM

Item ID: D412-760-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Cabin Wall and Pylon Protector

Stop

NS2

Start Date: 11/27/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011

Location: PC115

PPP Rev: _____

SK 12/12/12 *OS*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/12/2012

12/20/12

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

Picklist Print

November-30-12 9:20:44 AM

Page 1

Work Order ID: 94110

Parent Item: P412-760-111

Parera Item Name: Aft Cabin Wall and Pylon Protector

Start Date: 11/27/12

Required Date: 12/14/12

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1 Aft Wall Protector	Sm	Manufactured	No			110	Each	0.0000	1	94060	sf	12/12/18	OK
D3933-2 Aft Cabin Wall Protector, RH	Sm	Manufactured	No			110	Each	0.0000	1	94122		12/12/18	OK
D3935-1 Pylon Wall Protector, LH	Sm	Manufactured	No			110	Each	0.0000	1	94070	sf	12/12/18	OK
D3935-2 Pylon Protector	Sm	Manufactured	No			110	Each	0.0000	1	94108	sf	12/12/18	OK
D3942-0 Angle	Sm	Manufactured	No			110	Each	63.0000	14	14	-	JB	OK
						Location	Loc Qty	Loc Code					
						ST075	63						
						61450	3						
						61661	60						
D3942-3 Clip	Sm	Manufactured	No			110	Each	32.0000	10	10	61661	JB	OK
						Location	Loc Qty	Loc Code					
						ST075	32						
						68530	32						
MS270394310 Screw	Sm	Purchased	No			110	Each	48.0000	4	4	68530	JB	OK
						Location	Loc Qty	Loc Code					
						ST307	48						
						114742	48						
MS270394413 Screw	Sm	Purchased	No			110	Each	12.0000	6	6	114742	JB	12/12/18
						Location	Loc Qty	Loc Code					
						ST307	12						
						119510	12						

NCR: Yes / No

DQA: Date: . . .

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

November-30-12 9:20:44 AM

Page 2

Work Order ID: 94110

Parent Item: D412-760-111

Parent Item Name: Aft Cabin Wall and Pylon Protector

Start Date: 11/27/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

MS27039-S-03

SCREW

5mP

Purchased No 110 Each 13.0000

6

JB

MS27039-S-12

Screw

5mP

Purchased No 110 Each 56.0000

8

JB 12/12/18

Location Loc Qty Loc Code

ST308 13

115756 13

Location Loc Qty Loc Code

ST308 56

114037 56

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
				Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
				Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>					
				Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					

REFERENCE ONLY

Smf

DART AEROSPACE LTD.

IIN-D412-760

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Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
L10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1	1			D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1	1			D3952-1	PLACARD
		1		D3952-3	PLACARD
1				D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Revision: F
 Date: 12.08.30